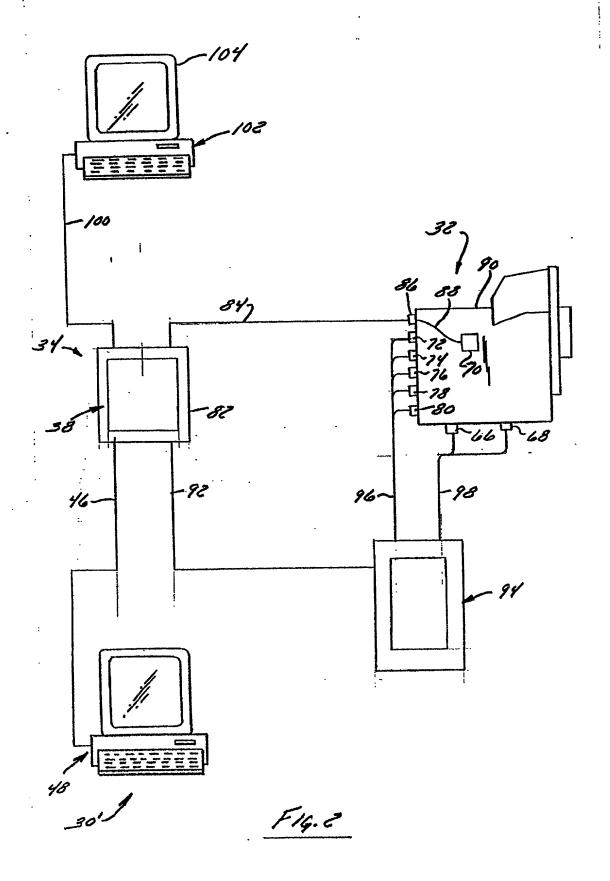
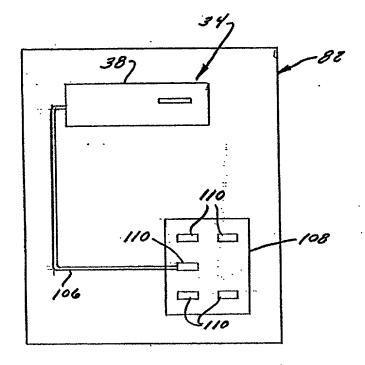
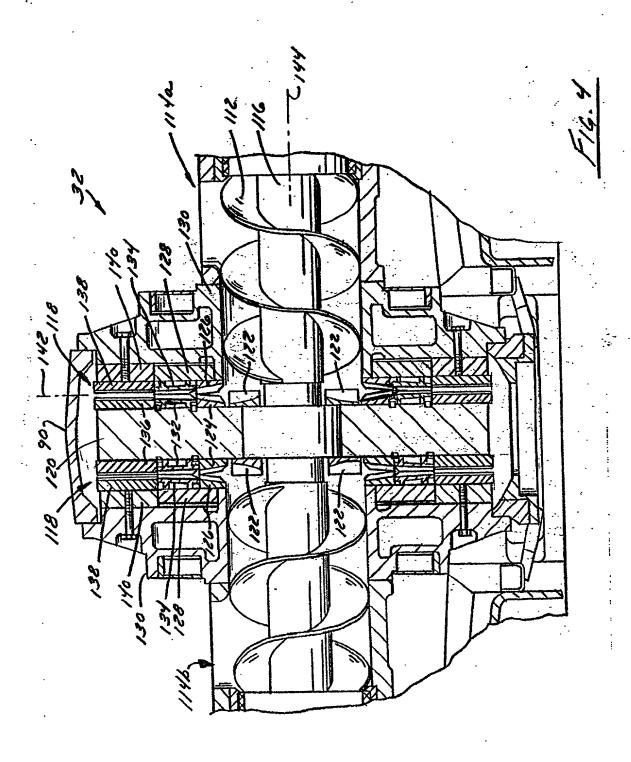


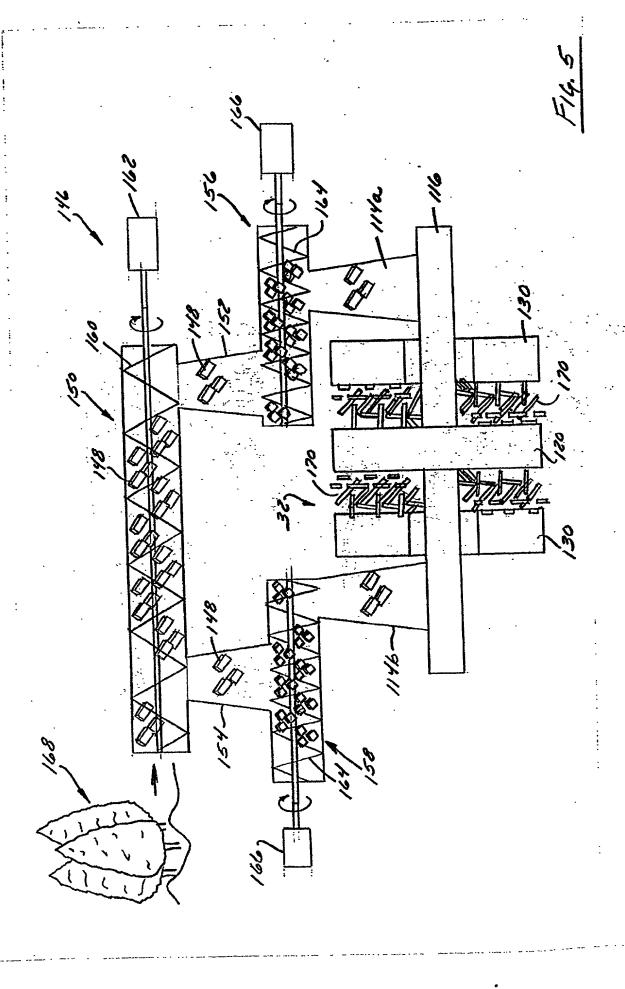
F14.1





F14.3





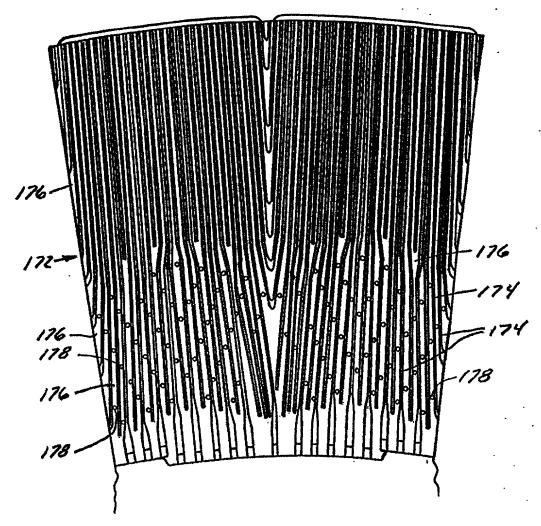
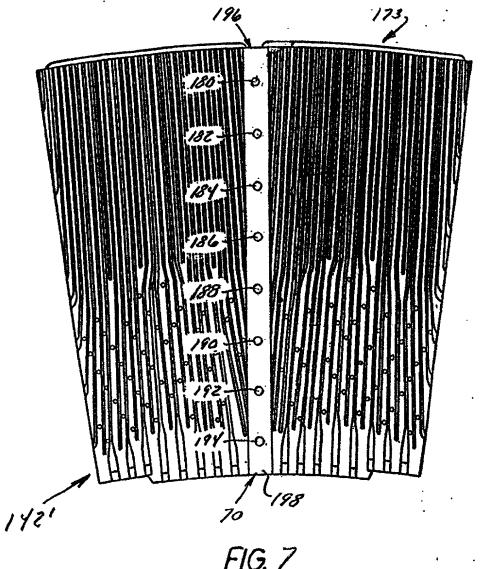
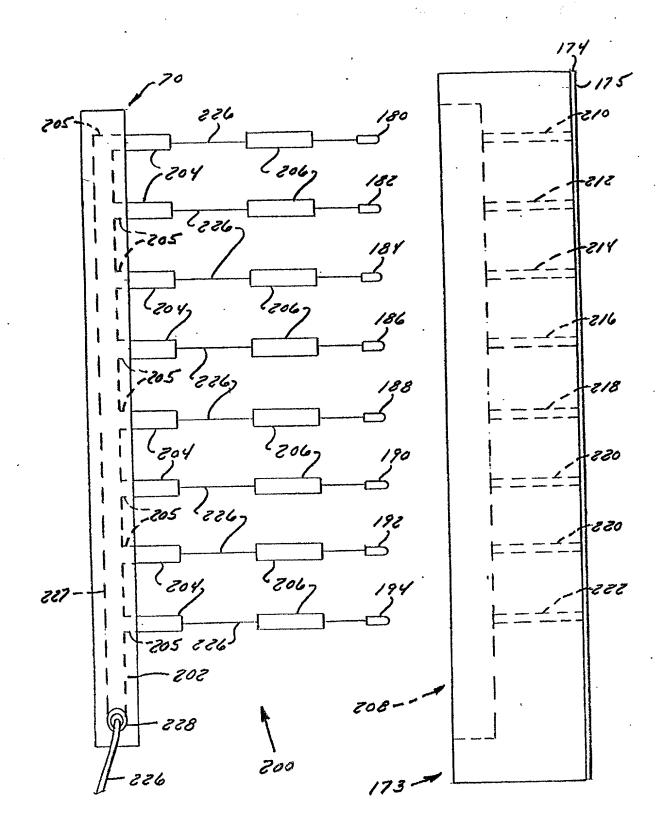


FIG. 6



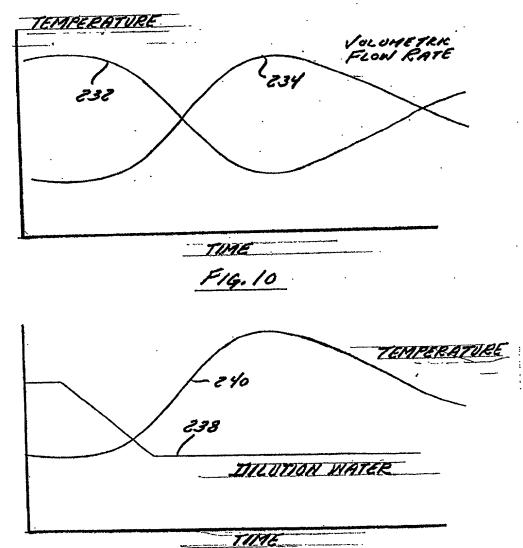


F14.8

TEMPERATURE
230

FEED SCREW RPM

F14.9



F14.11

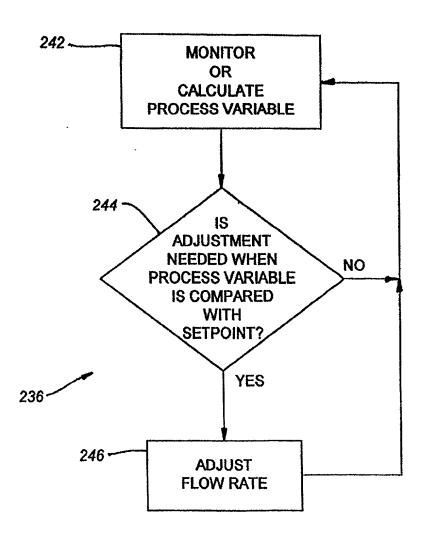
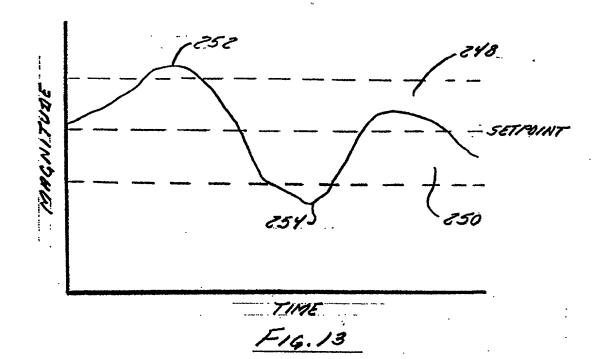
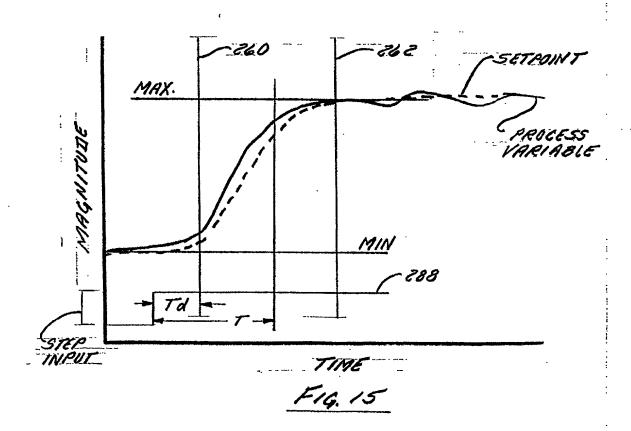


FIG. 12





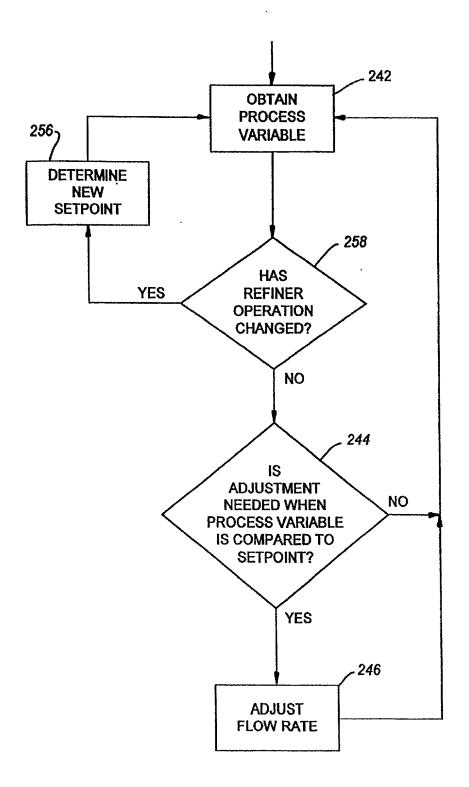


FIG. 14

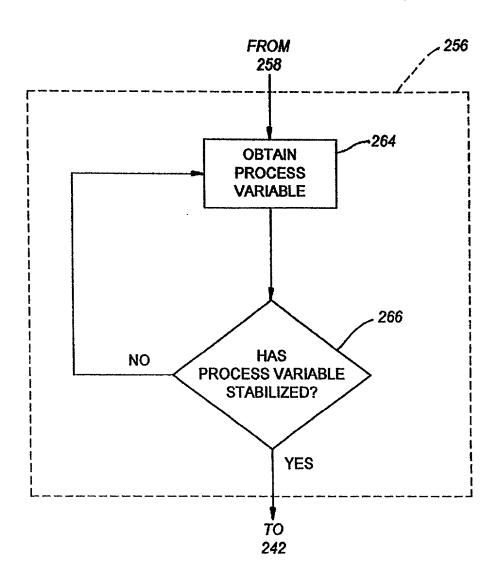


FIG. 16

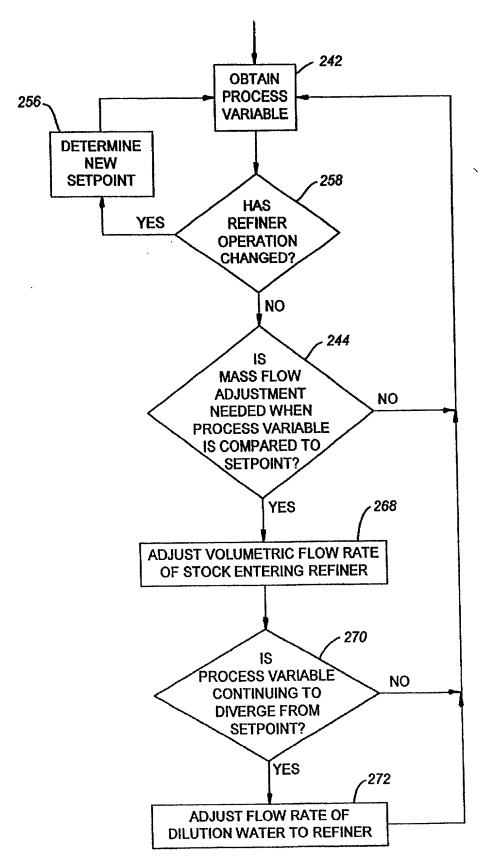
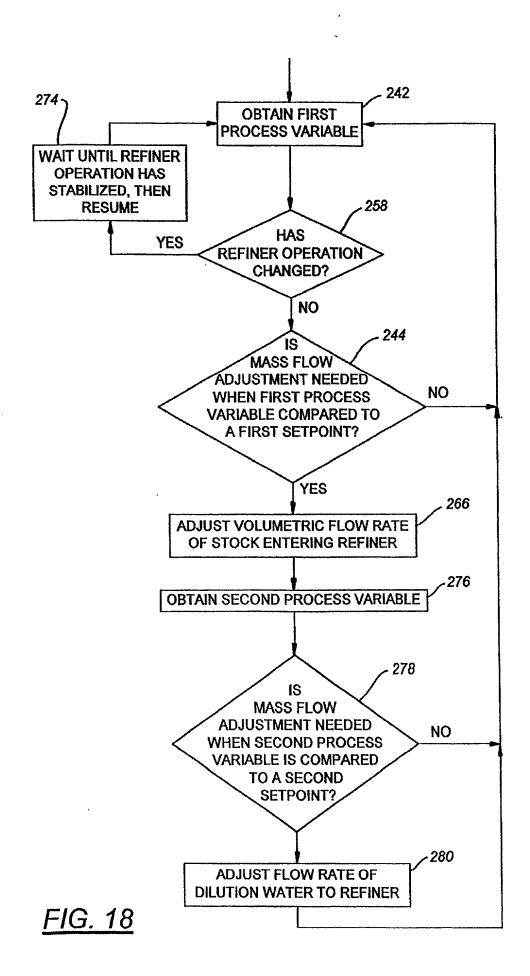
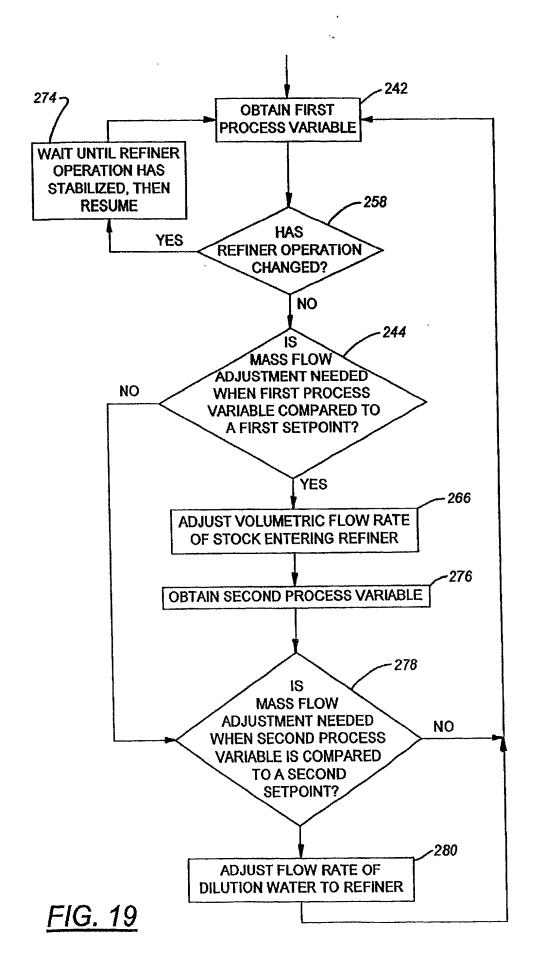


FIG.17





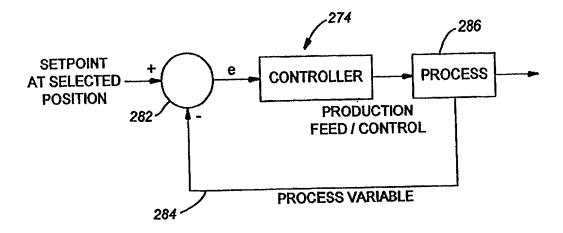
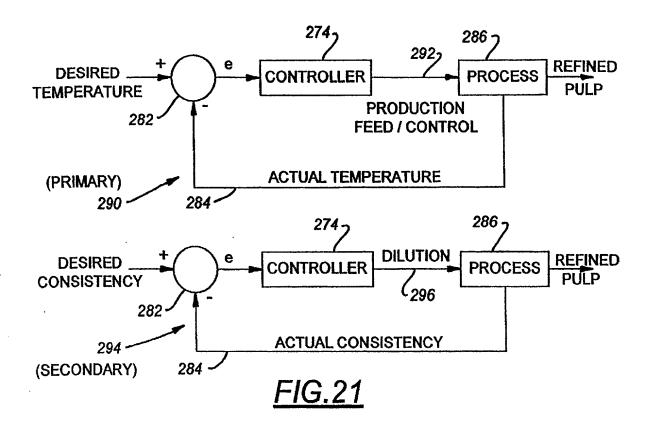
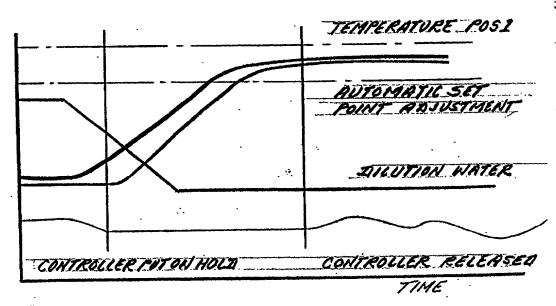
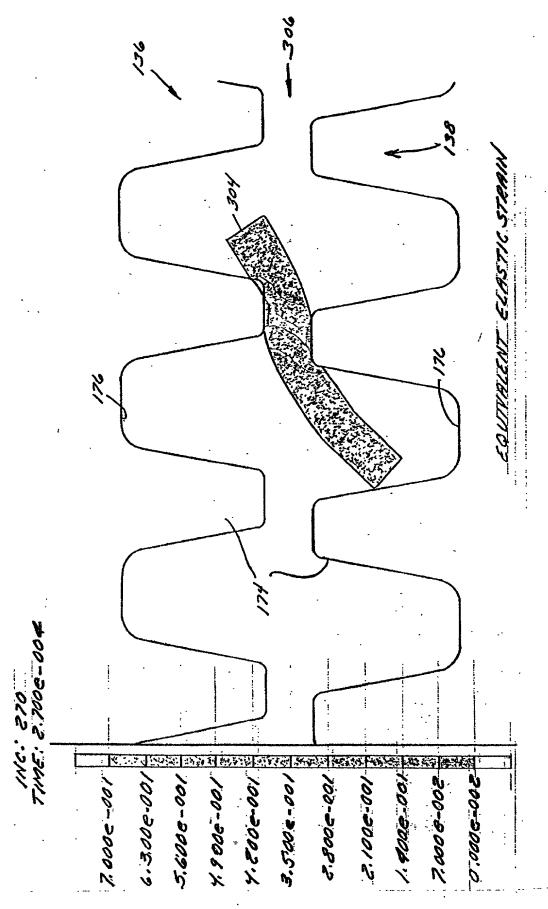


FIG. 20

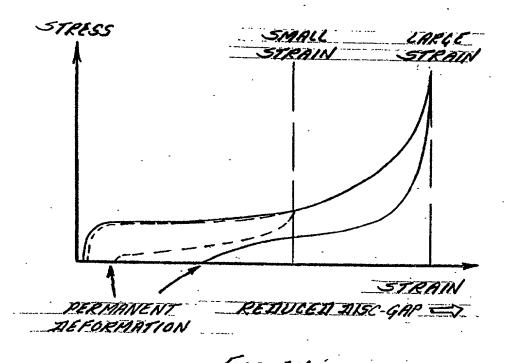




F14.22

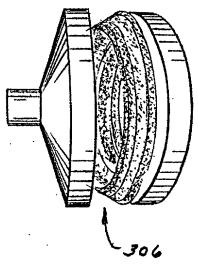


110.23



F1G. 24

171.7 166.5 161.4 156.2 151.0 145.8 170.7 133.5 130.3



F14.25

